

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-019923**Date Inspected:** 03-Feb-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1500**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC) Chanxing Island**Location:** Shanghai, China

CWI Name:	N / A			CWI Present:	Yes	No	
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A

Bridge No: 34-0006**Component:** OBG Segment**Summary of Items Observed:**

On this date CALTRANS OSM Quality Assurance (QA) Inspector Santhosh Ramakrishna was present during the times noted above for observations relative to fabrication work of the Self Anchored Suspension (SAS) Superstructure being performed.

This QA inspector randomly observed the following work:

1. INPROCESS:

Orthotropic Box Girder (OBG) at Bay-14 Area:

This QA observed that no significant work was being performed on Bay-14 area during the time of inspection. See the attached picture.

During the random visual inspection of welds located on Segment 14E at bike path side, this Quality Assurance Inspector (QA) observed that Linear longitudinal indication on back gouged area of vertical shear plate to anchorage plate weld. The Linear longitudinal Indication is measured approximately 50 mm in length. This weld is a Complete Joint Penetration (CJP) weld joining the vertical shear plate to anchorage plate weld joint is identified as SEG3019BB-003. The vertical shear plate to anchorage plate weld members is identified as SPCM. This weld is designated as Seismic Performance Critical weld. OBG segment 14E is located south Side of Bay 14 area. QA marked the Linear longitudinal indication near the weld area & also marked the Magnetic particle Testing (MT) of full weld requirements prior to weld. See the attached picture.

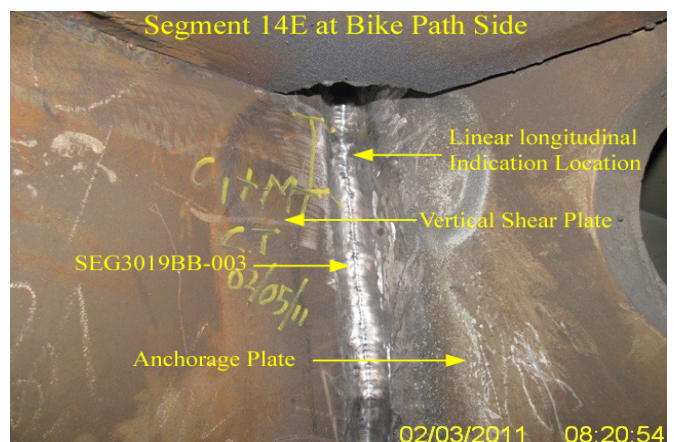
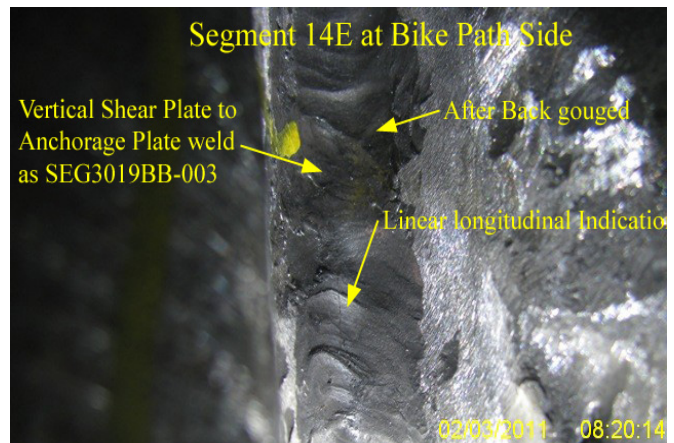
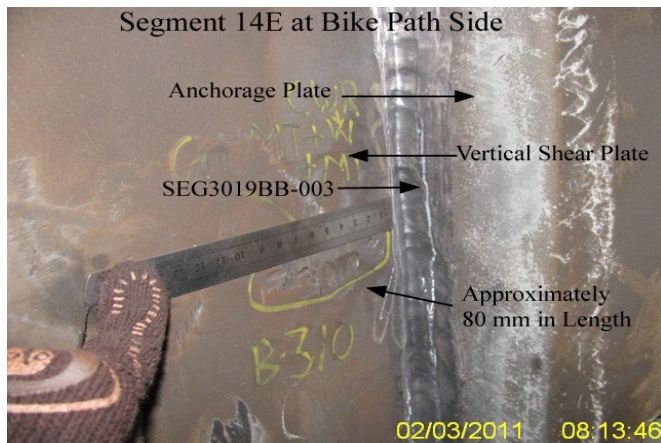
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During the random visual inspection of welds located on Segment 14E at bike path side, this Quality Assurance Inspector (QA) observed that base metal removal on temporary attachment removal area of vertical shear plate located near to the vertical shear plate to anchorage plate weld is identified as SEG3019BB-003. The base metal removal is measured approximately 80 mm in length & 2mm in depth. The vertical shear plate to anchorage plate weld members is identified as SPCM. OBG segment 14E is located south Side of Bay 14 area. QA marked the base metal removal on temporary attachment removal area near the weld area & also marked to prepare the weld repair report prior to weld. See the attached picture.

This QA inspector reviewed the contractor documents like approved drawings, weld maps, critical weld reports & RFI's.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



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Summary of Conversations:

No relevant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Pillai,Santosh	Quality Assurance Inspector
Reviewed By:	Miller,Mark	QA Reviewer
